

# Work Order ID 52318

Tuesday, September 22, 2009 2:51:57 PM



Page 1

Item ID: D3407-5	Accept		Setup	Start	
Revision ID: E				Stop	
Item Name: Ring					
Start Date: 9/23/2009	Start Qty: 20.00		Cust Item ID:		
Required Date: 10/9/2009	Req'd Qty: 20.00		Customer:		

Reference:

Approvals:	Process Plan: <u>PL MB</u>	Date: <u>09-22</u>	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3407	Rev E								

100

0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3407 ☒ Dwg Rev: E ☐ Prog Rev: E ☐ 2-  
Break edges on grinder as per Dwg D3407

Debrn m-l 09/10/21

HB 9-10-19



110

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

HB 9-10-19

120

0.00



QC8- Inspect parts - second check

QC

Memo

0.00

Quality Control

→ S 09/10/21



φ

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Item ID: D3407-5

Accept



Setup Start



Revision ID: E

Stop



Item Name: Ring

Start Date: 9/23/2009 Start Qty: 20.00



Cust Item ID:

Required Date: 10/9/2009 Req'd Qty: 20.00



Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run HoursDraw  
NumberDraw  
Rev.Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

130

Identify as per dwg & Stock Location: CL

0.00



Packaging

Memo

0.00

Packaging

9/10/23 (200) SP

140

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

09.10.27

MF  
09-10-23

# Picklist Print

Page 1

Tuesday, September 22, 2009 2:51:56 PM

Work Order ID: 52318



Parent Item: D3407-5RevE



Parent Item Name: Ring

Start Date: 9/23/2009

Required Date: 10/9/2009

Comments:

Start Qty: 20.00

Required Qty: 20.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M174B0.250X4.000		Purchased	No			100	f	18.6817	5.6126			
17-4 SS Bar .250 X 4.00												

1894079

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

MAT

18.6817

111699

11.9917

112331

6.69

111699

SHOP COPY  
RETURN TO  
ENGINEERING

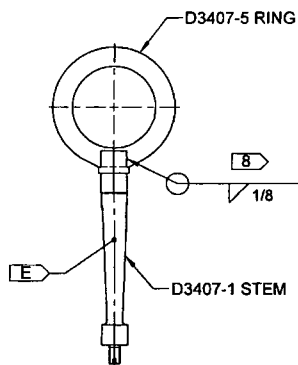
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT

WITHOUT NOTICE

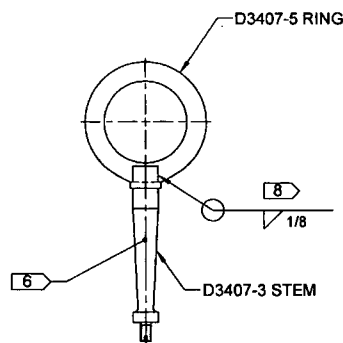
WORK ORDER

NO. 52318

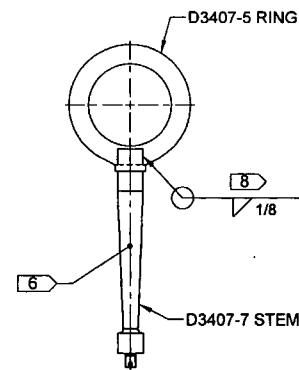
QTY -041	QTY -043	QTY -045	PART NUMBER	DESCRIPTION
X			D3407-041	TOW RING
	X		D3407-043	TOW RING
		X	D3407-045	TOW RING
1			D3407-1	STEM
	1		D3407-3	STEM
1	1	1	D3407-5	RING
		1	D3407-7	STEM



D3407-041 TOW RING



D3407-043 TOW RING



D3407-045 TOW RING

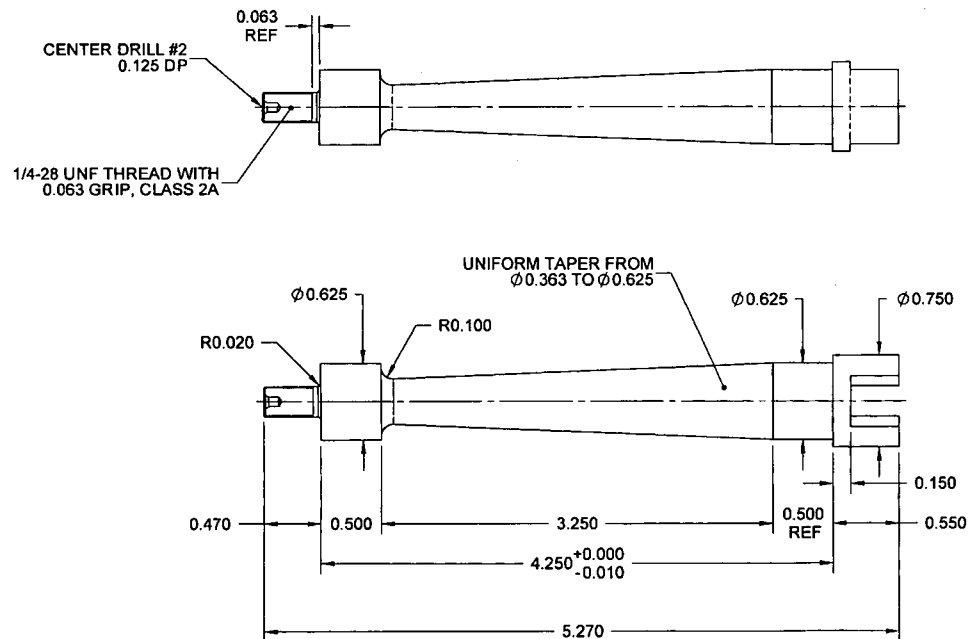
NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3 (EXCEPT THREADS)
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3407-XXX" USING BLACK FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: D3407-041 - 0.60 lbs, D3407-043 - 0.53 lbs, D3407-045 - 0.61 lbs
- 8) WELD PER DART QSI 004 ON ALL EDGES BETWEEN STEM AND RING

REV.	DESCRIPTION	BY	DATE
E	ADD D3407-045 (ZN B2-1, D8-1); ADD D3407-7 (ZN B6-5); REVISED NOTE 6 TO ADD IDENTIFICATION (ZN A5-1); REASON: PRODUCTION FACILITY	PH	08.07.23
D	D3407-1/3 SLOT WAS ROUND NOW FLAT FOR ASSEMBLY WITH D3407-5 (ZN C2-2, C2-3); D3407-5 WAS ROUND NOW FLAT ON ONE END FOR ASSEMBLY WITH D3407-1/3 (ZN B6-4); REASON: PRODUCTION FACILITY	PH	08.04.07
C	-1/3 LONGER FOR FIT W/WASHER	CP	05.09.09
B	UPDATE DIAMETER, THREAD CLASS ADDED	CP	05.06.17
A	NEW ISSUE	CP	05.03.16
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	08.07.23		

DART AEROSPACE USA, INC. PORT HADLOCK, WA	
DRAWING NO. D3407	REV. E
TITLE TOW RING	SHEET 1 OF 5
SCALE NTS	
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52815

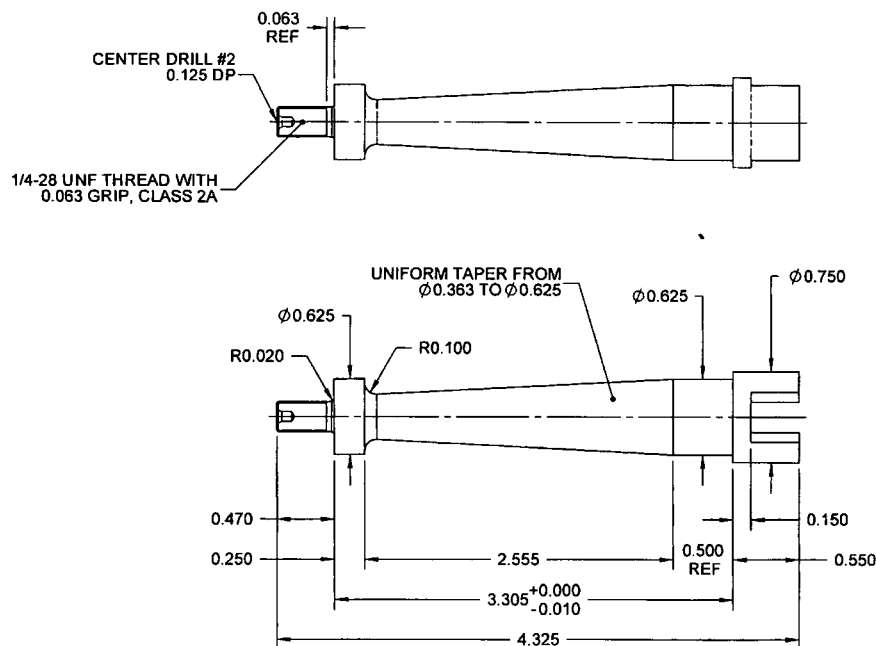


**D3407-1 STEM**

- NOTES:**
- 1) MATERIAL: 17-4 PH SS ROUND BAR PER AMS 5643 (REF. DART SPEC M17-4-R)
  - 2) FINISH: NONE
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: MACHINE ALL INSIDE EDGES WITH A 0.010 RADIUS
  - 6) IDENTIFICATION: N/A
  - 7) WEIGHT: 0.33 lbs

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MFG. APPR.		<b>D3407</b>	SHEET 2 OF 5
APPROVED		TITLE	SCALE
DE APPR.		<b>TOW RING</b>	NTS
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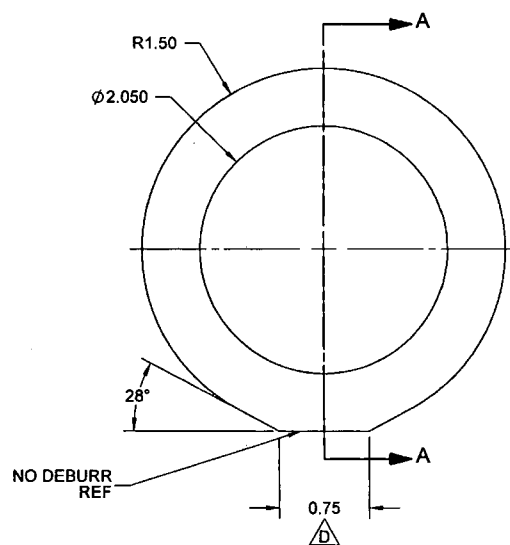
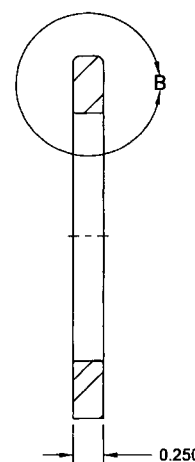
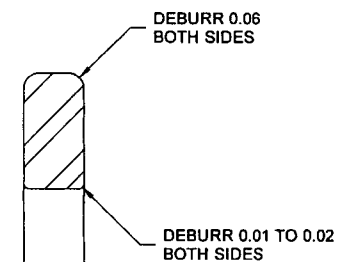
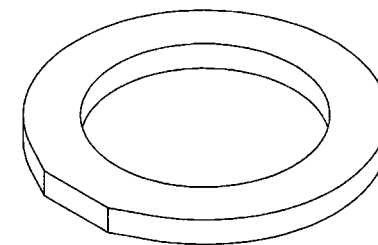
**D3407-3 STEM**

- NOTES:**
- 1) MATERIAL: 17-4 PH SS ROUND BAR PER AMS 5643 (REF. DART SPEC M17-4-R)
  - 2) FINISH: NONE
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: MACHINE ALL INSIDE EDGES WITH A 0.010 RADIUS
  - 6) IDENTIFICATION: N/A
  - 7) WEIGHT: 0.27 lbs

DESIGN	92	<b>DART AEROSPACE USA, INC.</b>	
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MFG. APPR.		<b>D3407</b>	SHEET 3 OF 5
APPROVED		TITLE	SCALE
DE APPR.		<b>TOW RING</b>	NTS
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**RELEASED**

52318

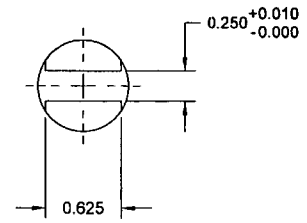
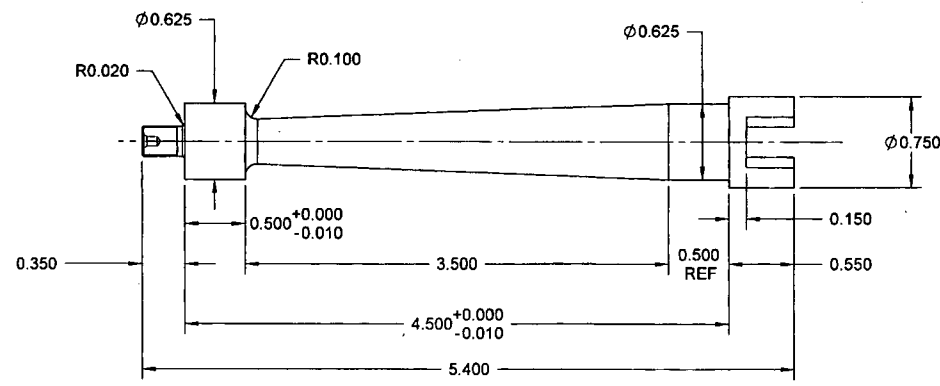
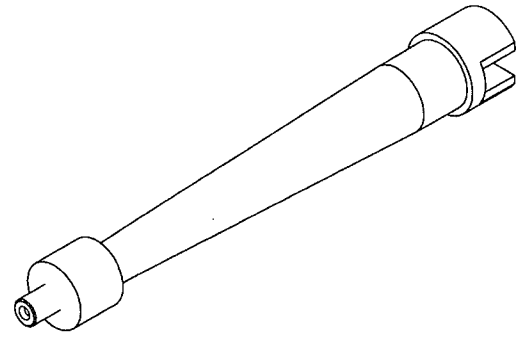
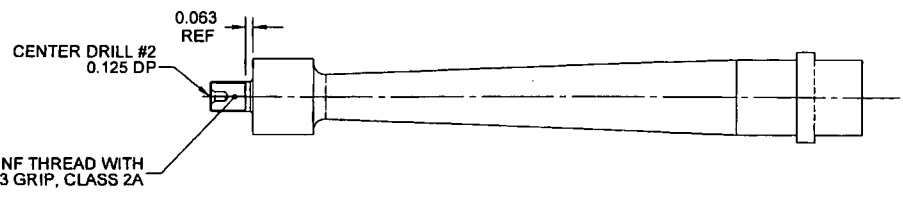
**D3407-5 RING****SECTION A-A****DETAIL B**  
SCALE 2X**RELEASED**  
06-08-2014

- NOTES:**
- 1) MATERIAL: 17-4 PH SS BAR PER AMS 5604/5643 (REF. DART SPEC M17-4-B)
  - 2) FINISH: NONE
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: N/A
  - 6) IDENTIFICATION: N/A
  - 7) WEIGHT: 0.27 lbs

DESIGN	90	<b>DART AEROSPACE USA, INC.</b>	
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MFG. APPR.		D3407	SHEET 4 OF 5
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52318

8 7 6 5 4 3 2 1



**D3407-7 STEM**

**RELEASED**

- NOTES:
- 1) MATERIAL: 17-4 PH SS ROUND BAR PER AMS 5643 (REF. DART SPEC M17-4-R)
  - 2) FINISH: NONE
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: MACHINE ALL INSIDE EDGES WITH A 0.010 RADIUS
  - 6) IDENTIFICATION: N/A
  - 7) WEIGHT: 0.34 lbs

DESIGN	AJS	<b>DART AEROSPACE USA, INC.</b>	
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8 7 6 5 4 3 2 1



<b>DART AEROSPACE LTD</b>		<b>Work Order:</b>	52918
<b>Description:</b> Tow Ring		<b>Part Number:</b>	D3407-5
<b>Inspection Dwg:</b> D3407 <b>Rev:</b> E			<b>Page 1 of 1</b>